

Date: Tuesday, 1/31/2006 1:14:37 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 204 SKIDTUBE "I" BEAM
Job Number	: 25698		
Estimate Number	: 10996		
P.O. Number	: N/A	Part Number	: D2597
This Issue	: 1/31/2006 S.O. No. : N/A	Drawing Number	: D2597 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: D
Previous Run	: 25336 Type : LANDING GEAR	Material	: N/A
Written By	: See comment below	Due Date	: 2/7/2006 Qty: 2 Um: Each
Checked & Approved By	: JF 06.01.31		
Comment	: Est: D 98.10.15 Eliminated DEO, Changed Dwg Revision KS		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Ext'n - 'I' Beam Web 4"	
			
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Extrusion "I" Beam Web 4"	
		Pick; Qty Part Number Description Batch	<p>3/5/00</p> <p>a.m 06-02-06 ②</p>
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 Cut D2500-3 to length: 84.25" a.m 06-02-06 ② Use Jig DT8094 to drill pilot holes. a.m 06-02-06 Open to 0.625 diameter using a uni-bit. a.m 06-02-06	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<p>BE 06-02-07 ①</p>
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1	<p>a.m 06-02-07 ①</p>
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
		Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	<p>B 06-02-08</p>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: LG

PM 06-02-08 (Z)

7.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAT 06/02/08 (Z) (S) 06/02/08

Job Completion



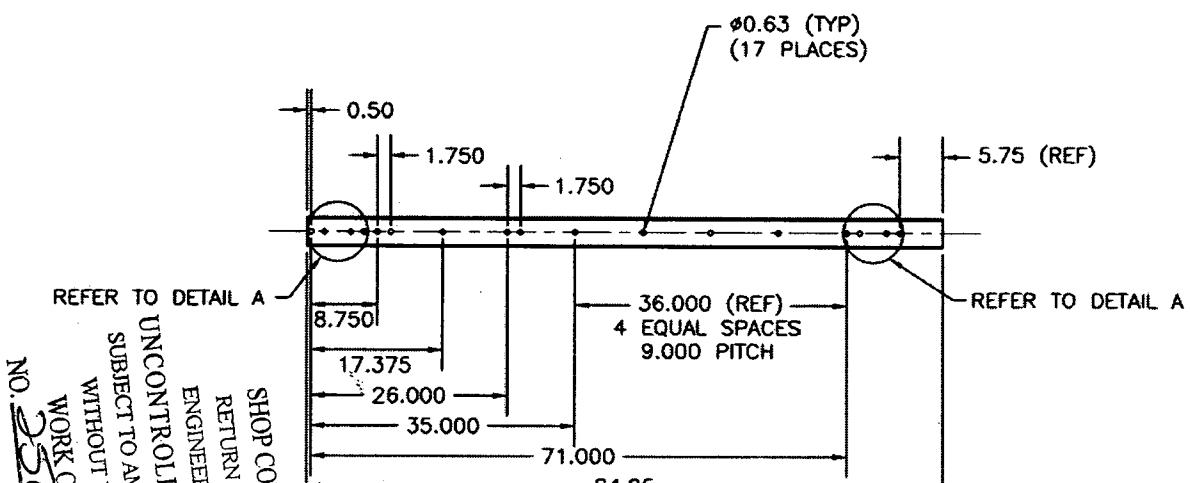
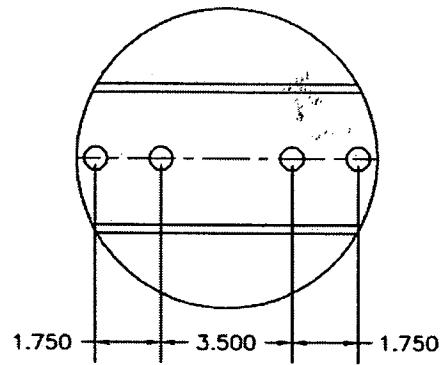
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/02/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A
SCALE 5:24



REFER TO DETAIL A
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 23678

MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
98.9.11
J.S.

DART

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DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2597
<i>J.S.</i>	<i>J.S.</i>	REV. D
DATE	TITLE	SHEET 1 OF 1
98.09.14	204 WEB	SCALE 1:24
A	96.09.16	NEW ISSUE
B	96.10.29	5.75 WAS 0.50
C	97.07.23	\$0.63 WAS \$0.56
D	98.09.14	INCORPORATED DEO 9097